

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021022**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Steve Jensen and William Sherwood			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder		

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 9E/10E side plate 'E2' (2638mm to 5278mm) inside, QA randomly observed ABF/JV qualified welder Sungtao, Huang ID # 3794 continuing to perform CJP groove (splice) welding fill pass to cover pass on the splice butt joint after fixing the Bug-o remote controller. The welder was observed perform automatic welding in the 3G (vertical) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joint being welded has a single V-groove butt joint with backing bar. The splice joint was preheated and maintained to greater than 150 degrees Fahrenheit using Miller Proheat 35 Induction Heating System heater blankets located at the opposite side of the plate prior/during welding. During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters of the welder. At the end of the shift, cover pass welding was completed and according to the welder he is moving to OBG 9W/10W side plate 'E' inside for his next welding work.

At OBG 8W-PP70.5-W5-SE deck access hole to top deck plate inside, QA randomly observed ABF/JV qualified welder Jorge Lopez perform CJP repair welding. The welder was noted excavating the three repairs using carbon air arc gouging. After gouging the three repairs, the welder smoothly ground the surface of the excavated groove and called ABF QC Fred Von Hoff for Magnetic Particle Testing (MT) prior welding. This QA has observed QC perform the MT which he found no indication during the test. Since there was no more time left to perform the

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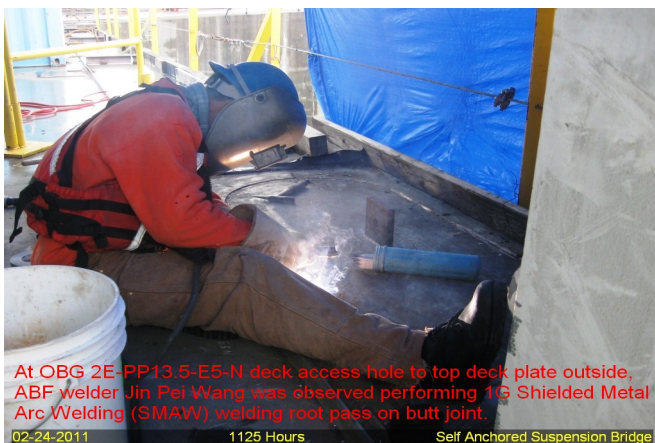
welding repairs, the welder and QC informed QA that they will be done tomorrow. The locations of the repairs were noted below;

Location	Y-dimension	Length	Width	Depth	Remarks
1.	3285mm	80mm	25mm	6mm	Inside- Excavated
2.	3605mm	115mm	25mm	7mm	Inside- Excavated
3.	90mm	130mm	20mm	5mm	Inside- Excavated

At OBG 6E-PP37.5-E5-N deck access hole infill plate to top deck plate inside, QA randomly observed ABF/JV qualified welder Han Wen Yu continuing to perform CJP groove root pass welding. The welder was observed welding in the 4G (overhead) position utilizing SMAW with 1/8" diameter E7018H4R electrode implementing Caltrans approved welding procedure ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint with open root. ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. At the end of the shift, root pass welding of the butt joint at location mentioned above was still continuing and should remain tomorrow.

At OBG 2E-PP13.5-E5-N deck access hole infill plate to top deck plate outside, QA randomly observed ABF/JV qualified welder Jin Pei Wang continuing to perform CJP groove root pass welding. The welder was observed welding in the 1G (flat) position utilizing SMAW with 1/8" diameter E7018H4R electrode implementing Caltrans approved welding procedure ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint with open root. ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. At the end of the shift, root pass welding of the butt joint at location mentioned above was still continuing and should remain tomorrow.

At OBG 8W/9W side plate 'E' outside, ABF welder Rory Hogan was noted continuing to prepare his welding equipment and welding cover protection. No welding was performed at this location today. Also at OBG 9E/10E edge plate 'B' inside, ABF welder Fred Kaddu was noted continuing to grind the groove of the excavated surface of the three repairs.



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Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer